

Work Order ID 63007

October 15, 2010 2:39:34 PM



Page 1

Item ID: D3183-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing

Start Date: 10/15/10 Start Qty: 50.00



Cust Item ID:

Required Date: 10/19/10 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CY Date: 10/10/15 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3183	Rev C1

100 0.00



PURCHASING

Purchasing

Memo 0.00

Purchasing

Issue P/O: 12751 ☐ Bearing as per Dwg D3183 ☐ Single row, deep groove, Conrad type, shielded ☐ Possible Supplier: NSK P/N 6800ZZ ☐ Certificate of conformity-note is required

CY 10/10/15 (50)

110 0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo 0.00

Packaging

Ensure certificate of conformity is attached

10/14/18 (50)

120 0.00



QC6- Inspect dimensions to drawing

QC

Memo 0.00

Quality Control

30
~~30~~
~~30~~

(30)

(810)

8 10/10/27

count
(+50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3183-5 PAR #: NCR10-371 ^{Supplier} Fault Category: Main Industrial NCR: Yes (No) DQA: [Signature] Date: 10.10.19
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>63007</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.10.19	120	20 of 50 bearings have rubber seal & me 6800 RS inside of # 680022 box	<u>[Signature]</u>	See NCR10-371 for corrective action details.	N/A <u>[Signature]</u>	<u>[Signature]</u> 10.10.19	<u>[Signature]</u>	<u>[Signature]</u> 10.10.19

NOTE: Date & initial all entries

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Required Date: 10/19/10 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>GT 236</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

mf

10-10-27

10/10/27

mf

10-10-27

Picklist Print

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Work Order ID: 63007



Parent Item: D3183-5



Parent Item Name: Bearing


Start Date: 10/15/10

Required Date: 10/19/10

Start Qty: 50.00

Required Qty: 50.00

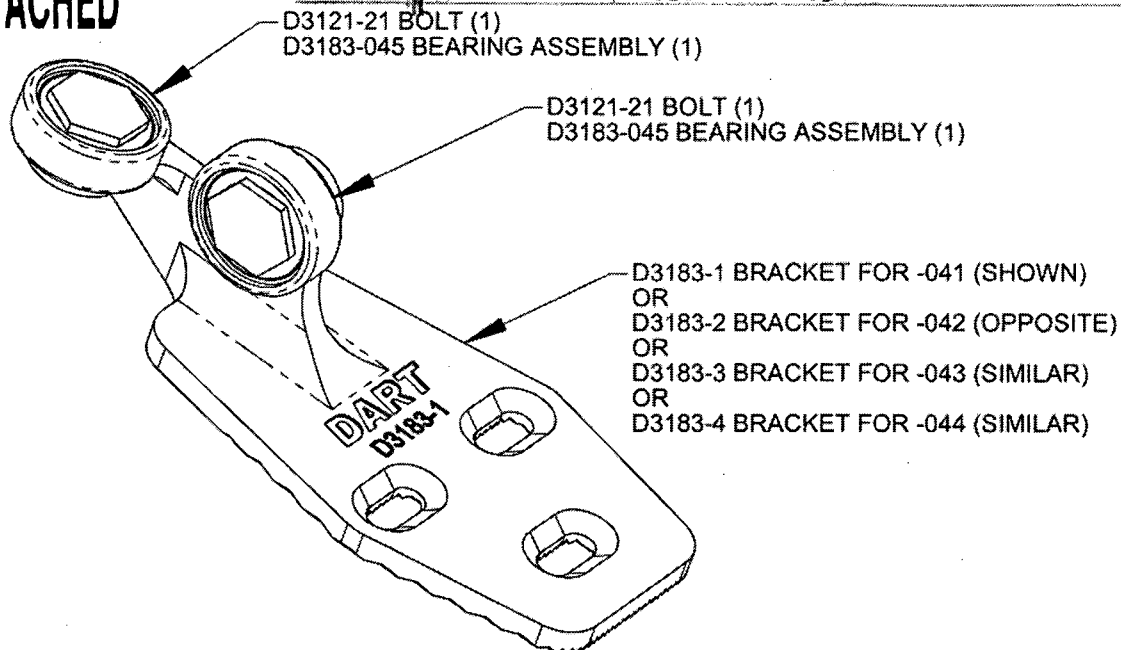
Comments: IPP: A ☐ 03.03.27 ☐ New issue ☐ KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6800ZZ  Bearing		Purchased	No			100	Each	0.0000	1	50		10/14/18	50

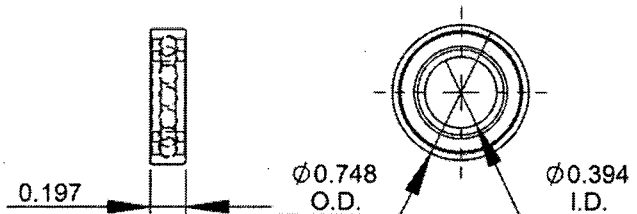


DESIGN #	DRAWN BY IP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	# 04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01 #
DEO ATTACHED



D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



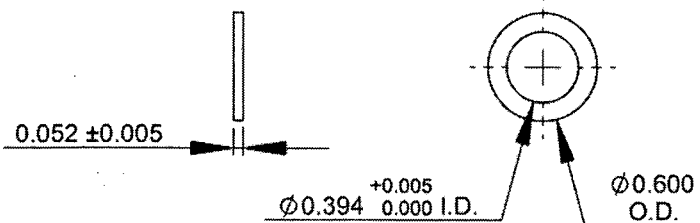
D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

C21011015
W10' 63007

D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q2</i>	CHECKED <i>J</i>	MFG. APPR. <i>A</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30		DATE 10/06/30		

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

W/O 63007

RELEASED
2010-07-22
W/O

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Non-Conformance Report				NCR 10-371	
Raised by: <u>Jason Lavelle</u>		Source: <u>Quality Inspection</u>		Sheet No. <u>1</u> of <u>1</u>	
Non-Conforming Dept./Supplier: <u>Main Industrial</u>		Date: <u>Oct 19 2010</u>		Priority: <u>HIGH</u> <u>LOW</u>	
Product/Service: <u>D3183-S 680022</u>					
Area of Standard: <u>Section A</u>		Description of Non-Conformance: <u>Qty 20 bearings have rubber seal (6800 RS) packaged inside of a 6800 22 box (steel outside)</u>			
QSI					
QSP					
QSPM					
Documents:		20 of 50 bearings have rubber seal. Remaining 30 are acceptable.			
P/O <u>12751</u>					
Invoice					
W/O <u>63007</u>					
Batch No.					
TSR		Root Cause:			
Drawing <u>D3183 Rev C</u> <u>DEC 3183-C1-1</u>					
Forward to Director, Quality Assurance on completion of Section A					
DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.					
Section B		Responsible for Investigation/CA: <u>L. Lavelle</u> To be done by: <u>10/10/31</u>			
Corrective Action					
No	Initial	Action Description	Responsible	Due date	Sign/Date
1	J.M.	Split up Return the 20 RS bearings back to supplier, informing them of the issue. Have them respond via letter or e-mail. As to how they are handling the kate error, submit a copy of their corrective action for our records.	C. Lavelle (LL) on ap	10/10/31	
2	J.M.	Replacement bearings as necessary: split up P.S replacement will be done oct 25 2010	C. Lavelle	10-10-22	C/L 10/19/21
Preventive Action Required: NO YES # _____					Fault Category:
Section C					
Verification of C/A Responsible for Verification of CA: _____					
No	Verification Method	Sign	Date	Forward to DQA on Completion of Verification	
DQA: _____				Date: _____	
QA Purposes only N/C Closed Date					

Chantal Lavoie

From: Eric Bourgon [eric@mainindustrialsales.com]
Sent: October 21, 2010 11:38 AM
To: Chantal Lavoie
Subject: 6800-ZZ

Hi Chantal,

My supplier had put the wrong bearings (6800-ZZ) in the box.
The information on the purchase order is totaly right but we sent you the wrong bearings.
We will do an exchange tomorrow.

Thanks
Eric



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO12751**

Purchase Order Date 10/15/10

PO Print Date 10/15/10

Page Number 1 of 1

Order From :

VC-MAI001

MAIN INDUSTRIAL SALES LTD.
1475, TESSIER
HAWKESBURY, ON K6A 3S6
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

613 632 3595

613 632 0262

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

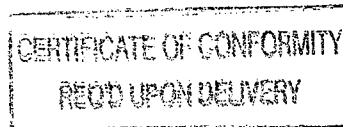
FAKED
C & Controls

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	6800ZZ	Bearing	10/18/10 Yes	50.00 Each	Yours ppd	\$1.6200	\$81.00

Special Inst: AS PER DWG D3183 REV. C
B63007
SINGLE ROW, DEEP GROOVE, CONRAD
TYPE,
SHIELDED NSK P/N: 6800ZZ

PO Total:

\$81.00



Change Nbr: 1

Change Date: 10/15/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

MAIN INDUSTRIAL SALES LTD.

1475 TESSIER ST.
HAWKESBURY ON K6A 3S6
Phone: (613) 632-3595 Ext. Fax: (613) 632-0262
sales@mainindustrialsales.com

Packing Slip

DATE October 15, 2010
NUMBER 0000139084
CUSTOMER NO. DART

BILL TO:

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON K6A 1K7

SHIP TO:

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON K6A 1K7

(613) 632-5200 Ext.

(613) 632-5200 Ext.

P.O. NUMBER	SALESPERSON	ORDER DATE	REQ. DATE	ORDER NUMBER
12751	EB	15-Oct-10		0000139084
F.O.B.	SHIP VIA	TERMS		
F.O.B. value	PICK UP	NET 30 DAYS		
PART NUMBER	UOM	QUANTITY		
DESCRIPTION		REQ.	SHIPPED	B.O.
0-68002ZKML BALL BEARING YOUR PART #: 6800ZZ	EA	50	50	